



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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DAS
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9-88

RBBP1425-103-03
Job Sheet 188960



Part No: RBBP1425-103-03

Job Qty: 12 pcs

Part Name: Keeper



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/17/19

Job Tracking No:

Due Date: 2/1/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBBP1425-101 Rev D IPP Rev A 18.03.13 New issue DP Verify DD/DWG RBBP1425-101 Rev D IPP Rev B 18.04.04 DWG update DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Waterjet - Omax - 1	12 pcs	2/1/19	2/1/19	0.00	1.20	Waterjet - Omax	DL 19/03/05
110	SL-2500Y - B4B	12 pcs	2/1/19	2/1/19	0.00	6.00	SL-2500Y -1 - B4B	DL
120	QC 2	12 pcs	2/1/19	2/1/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	DL
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 38	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 54	
							QC 2 - 56	
							QC 2 - 57	
							QC 2 - 62	

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					QC 2 - 63	
					QC 2 - 8	
130	NV5000 - 1 - B4B	12 pcs	2/1/19	0.00 3.00	NV5000 - 1 - B4B	PT 19-03-22
					NV5000 - 2 - B4B	
140	QC 2	12 pcs	2/1/19	0.00 0.00	QC 2 - 1	PT 19-03-22
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	J.C.L.
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 38	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 54	
					QC 2 - 56	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	
150	QC 8	12 pcs	2/1/19	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 38	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	B.A 19-03-24
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
180	Outsource - 12 - Black Oxide	12 pcs	2/1/19		GRO002-VC	10 03/25/2019 PL
200	Packaging 2-1 - Receive - B4B	12 pcs	2/1/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	

				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
210 QC 6	12 pcs	2/1/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
215 Packaging 3-1 - Stock - B4B	12 pcs	2/1/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	

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				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
220	QC 21 - SA	12 pcs	2/1/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70

Part Op **100** - (Waterjet 2) 1-Cut blanks (RED BARN FOLDER) ***Note***makes four pieces***
 Descriptions: **110** - (MORI SL2500Y LATHE) 1-Machine as per folio FC025 FOLIO REV: AA DWG REV: D 2-
 Deburr
120 - (QC2- Inspect parts off machine FAI/FAIB)
130 - NV5000-1 (MORI SEIKI VERTICAL MACHINE #1) 1-Machine as per folio FC025 FOLIO REV: AA DWG
 REV: D ***Note***makes four pieces*** 2-Deburr 3-Machine engrave as per note 6
140 - (QC2- Inspect parts off machine FAI/FAIB)
150 - (QC8- Inspect parts - second check)
180 - (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-
 13924C Class 1 -Certificate of Conformity is required
200 - (Receive & Inspect for Damage & Mat'l Certs)
210 - (QC6- All purchased or subcontracted products)
215 - (Identify as per dwg & Stock Location: _____)
220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-0.500X10.000	AISI 4140 Steel Sheet/Plate	7.2000 ft (0.00ea)	100-Waterjet - Omax - 1	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Omax - 1	MT-4140-S-0.500X10.000	7	9	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Email: sales@dartaero.com
www.dartaerospace.com

Container No: S159485

Part: RBBP1425-103-03

Job No: 188960

Serial No/Batch: S159485

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 03/08/19

INSPECTION SHEET

[illegible]

Measured by:	Checked by:	QC Inspector:
Date:	Date:	Date:

Engineering Approval: (If necessary)		Date:
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
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PURCHASE ORDER **PO042978**



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042978

PO Date: 3/25/19

Due Date: 3/29/19

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

Revision

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	189489	RBE1X36-166-807-1	Spanner -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	3/29/19	3 pcs	0 pcs	3 pcs	\$3.428/pcs	\$10.28

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DP

Line Item Note ** NEED BACK MARCH 29,2019 * RUSH **

2	188960	RBBP1425-103-03	Keeper (Outside Processing - Black Oxide) -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	3/29/19	24 pcs	0 pcs	24 pcs	\$3.428/pcs	\$82.27
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DP

Line Item Note ** NEED BACK MARCH 29,2019 * RUSH **

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PURCHASE ORDER **PO042978**



Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	189499	RBE1X53-166-817-3	1-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	3/29/19	4 pcs	0 pcs	4 pcs	\$3.428/pcs	\$13.71
Line Item Note ** NEED BACK MARCH 29,2019 * RUSH **											
4	189500	RBE1X53-166-817-5	1-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Certificate of Conformity is required	Firmed	-	3/29/19	4 pcs	0 pcs	4 pcs	\$3.428/pcs	\$13.71
Line Item Note ** NEED BACK MARCH 29,2019 * RUSH **											
Grand Total:										\$119.98	



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PURCHASE ORDER
PO042978



Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

017970- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
01-Apr-2019		Shankar Anand		PO042978				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE1X36-166-807-1 Rev.	RBE1X36-166-807-1 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	3	3	0	0	0
2	RBBP1425-103-03 Rev.	RBBP1425-103-03 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS1	OXIDE-BLACK CH	24	24	0	0	0
3	RBE1X53-166-817-3 Rev.	RBE1X53-166-817-3 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4	0	0	0
4	RBE1X53-166-817-5 Rev.	RBE1X53-166-817-5 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL WIPE OFF EXCESS OIL	OXIDE-BLACK CH	4	4	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.